CEWELD Ni-Rod FM 99 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid Nickel based filler metal for TIG welding.

ANWENDUNGEN

CEWELD® Ni-Rod FM 99 Tig is developed for welding ductile, grey and malleable cast irons. He can also be used for dissimilar welding between cast iron and low alloyed steel or carbon steels.

EIGENSCHAFTEN

This Nickel weld deposit offers a easily machinable weld deposit with high ductility and no undercut.

KLASSIFIKATION

AWS	A 5.15: E Ni-Cl
EN ISO	1071: SC Ni-Cl

GEEIGNET FÜR

Grey cast iron, malleable, nodular, dissimilar welding : NF A 32-101 : FGL 150, 200, 250, 300, 350, 400. NF A 32-201 : FGS 370-17, 400-12, 500-7, 600-3, 700-2. NF A 32-702 : MN 350-10, 380-18, 450-6, 350-4, 650-3. DIN 1691 : CG-14, 18, 25, 30. DIN 1693 : GGG-40, 50, 60, 70. DIN 1692 : GTS-35, 45, 55, 65, 70.

ZULASSUNGEN

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

Ni	C	Mn	Fe	S	Si	Cu
Rem.	0.15	0.35	0.4	0.01	0.35	0.25

MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	250	490	15	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

I1, M11

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NI-ROD FM 99 TIG 1,6MM

Packaging	KG/unit	EanCode
Tube	5	8720663417855

NI-ROD FM 99 TIG 1,6 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663417862

NI-ROD FM 99 TIG 2,0 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663417879

NI-ROD FM 99 TIG 2,4 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663417886

NI-ROD FM 99 TIG 3,2 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663417893